Amendments to the Claims:

1. **(Previously Presented)** A framed panel unit comprising a panel;

a plurality of thermoplastic frame members disposed along the edge of said panel;

each frame member having first and second opposed side walls defining a channel therebetween, the edge of said panel being received within the channel of each frame member;

the channel of each frame member having spacer means therein including a first spacer between said panel and said first side wall for spacing said panel from said first side wall and a second spacer between said panel and said second side wall for spacing said panel from said second side wall and where prior to welding together the ends of said frame members, said spacer means positions said panel within said channel and further retains said frame members on said panel.

2. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein at least one of said first and second spacers includes a protrusion extending therefrom and engaging a respective side of said panel for resiliently retaining said frame member on said panel.

3. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein said channel of each frame member includes a base between the first and second opposed sidewalls, wherein each spacer means further comprises a third spacer arranged between the edge of said panel and the base of said channel and wherein said first and second spacers are coupled to said third spacer.

Claim 4 **(Cancelled)**

5. **(Previously Presented)** A framed panel unit as claimed in claim 3, wherein for each spacer means, the first and second spacers are hingedly coupled to said third spacer and the respective

junction between each of said first and second spacers and said third spacer is relieved to accommodate folding of said first and second spacers towards said third spacer.

6. **(Previously Presented)** A framed panel unit as claimed in claim 3, wherein said third spacer includes locator means for positioning said third spacer at a predetermined lateral position between the side walls of said channel and wherein the base of said channel has first and second oppositely sloped upper surfaces which slope transversely of said channel and said locator means includes first and second oppositely sloped lower surfaces of said third spacer which engage the sloped surfaces of said channel such that said third spacer is urged towards a central position within said channel on applying a force to said third spacer towards the base of said channel.

Claim 7 **(Cancelled)**

8. **(Previously Presented)** A framed panel unit as claimed in claim 3, wherein said third spacer includes means for permitting fluid to flow therethrough between adjacent portions of said channel separated by said third spacer.

Claims 9 and 10 **(Cancelled)**

11. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein said panel is comprising at least part of sheet glass.

Claim 12 **(Cancelled)**

13. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein at least one of said first and second spacers is positioned below the top of a respective channel wall to provide an open gap at the top of said side wall for receiving sealant.

14. **(Previously Presented)** A framed panel unit as claimed in claim 13, wherein said sealant material comprises a reactive thermoplastic sealant material.

Claim 15 **(Cancelled)**

16. **(Previously Presented)** A framed panel unit as claimed in claim 13, wherein said sealant is one of polyurethane based and silicone based.

Claim 17 **(Cancelled)**

18. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein at least one of said first and second spacers is integrally formed with a respective channel wall.

Claims 19-28 **(Cancelled)**

29. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein each said frame member further includes a series of pre-formed inserts between one of said first and second opposed side walls and an outer face of said panel for spacing said outer face of said panel from said side wall to define a gap therebetween for sealant material.

Claims 30 and 31 **(Cancelled)**

32. **(Previously Presented)** A framed panel unit as claimed in claim 29, wherein said inserts comprise a resilient rubber material and said framed panel unit includes friction reducing means between said inserts and said channel to facilitate relative movement between said inserts and each said frame member.

Claims 33-36 **(Cancelled)**

37. **(Previously Presented)** A framed panel unit as claimed in claim 18, wherein each of said at least one of said first and second spacers includes one or more protrusions integrally formed with and extending from the other side wall, and wherein said integrally formed protrusions comprise flexible plastic fins.

38. **(Previously Presented)** A panel unit as claimed in claim 37, wherein said integrally formed protrusions further comprise a flexible bulb seal located at the top of one of said side walls.

39. **(Currently amended)** A method of forming a framed panel unit, comprising the steps of:
(a) providing a panel to be framed;
(b) providing a plurality of thermoplastic frame members for ~~framing~~ to be disposed along the edge of said panel, each frame member having first and second opposed side walls defining a channel therebetween ~~formed therein~~ for receiving ~~an edge portion~~ the edge of said panel, the channel of each frame member having spacer means for positioning said panel within said channel and ~~resilient means within said channel for spacing the panel from opposed side walls of said channel and for~~ resiliently retaining each said frame member on said panel ~~in said channel~~, said spacer means including a first spacer between said panel and said first side wall for spacing said panel from said first side wall and a second spacer between said panel and said second side wall for spacing said panel from said second side wall;
(c) inserting said panel into the channel of each frame member such that said frame members are held on said panel by said ~~resilient~~ spacer means; and
(d) joining the ends of adjacent frame members together using a welding process.

40. **(Original)** A method as claimed in claim 39, wherein the step of joining comprises forming a plurality of welded joints using a separate welding station for each joint.

41. **(Original)** A method as claimed in claim 40, wherein the step of joining comprises forming said plurality of welded joints substantially simultaneously.

42. **(Previously Presented)** A method as claimed in claim 39, wherein the step of joining comprises

(e) positioning a weldable member between adjacent ends of two frame members; and

(f) welding each end to said weldable member by urging said frame members into engagement with said weldable member, and vibrating said weldable member to cause melting of material at the interface of each end and said weldable member.

43. **(Previously Presented)** A method as claimed in claim 42 further comprising performing steps (e) and (f) for each joint substantially simultaneously.

Claim 44 **(Cancelled)**

45. **(Previously Presented)** A method as claimed in claim 42, wherein the frame members are interconnected by junction pieces prior to transferring the assembled frame and panel components to a welding apparatus and wherein said junction piece incorporates integral legs.

Claim 46 **(Cancelled)**

47. **(Previously Presented)** A method as claimed in claim 42, comprising permitting said panel to move relative to each frame member for at least part of said joining step.

Claims 48-51 **(Cancelled)**

52. **(Previously Presented)** A method as claimed in claim 39, further comprising the step of applying sealant material between said panel and at least a portion of a frame member and wherein said sealant material is applied after said joining step.

Claim 53 **(Cancelled)**

54. **(Previously Presented)** A method as claimed in claim 52, further comprising the step of applying sealant material for bonding the frame members to the panel to both outwardly facing surfaces of said panel substantially simultaneously.

55. **(Previously Presented)** A method as claimed in claim 52, comprising applying said sealant material for bonding between said panel and said frame members after said joining step and when said panel is in a substantially upright position.

56. **(Previously Presented)** A frame member for a panel, comprising first and second opposed side walls defining a channel therebetween for receiving said panel;

first and second pre-formed spacers comprising a resilient material inserted in said channel;

the first spacer being positioned against said first side wall for spacing one side of said panel therefrom and said second spacer being positioned against said second side wall to space the other side of said panel therefrom, wherein said first and second spacers are mounted in said channel such that said spacers are capable of sliding along said channel; and

retaining means for retaining at least one of said first and second spacers in said channel to limit movement of said spacers in a direction transverse to the length of said channel towards the channel opening defined between said opposed side walls, wherein said retaining means is arranged to permit movement of said spacers in a direction along said channel.

Claims 57-64 **(Cancelled)**

65. **(Previously Presented)** A frame member for a panel, comprising:

first and second opposed side walls defining a channel therebetween for receiving said panel;

first and second pre-formed spacers comprising a resilient material inserted in said channel;

the first spacer being positioned against said first side wall for spacing one side of said panel therefrom and said second spacer being positioned against said second side wall to space the other side of said panel therefrom; and

a third spacer positioned at the base of said channel for spacing said panel from said base, wherein said third spacer is coupled to at least one of said first and second spacers; and

biasing means between said third spacer and at least one of said first and second spacers for urging a respective spacer outwardly into engagement with a respective channel wall;

wherein said third spacer has a lower surface which engages the base of said channel and said third spacer includes a formation on its lower surface, and the base of said channel includes a complementary formation to locate said third spacer at a predetermined position between the side walls of said channel when said formations engage.

Claims 66-70 **(Cancelled)**

71. **(Previously Presented)** A frame member as claimed in claim 65, wherein said third spacer includes oppositely sloped lower surfaces providing said formation and the base of said channel includes complementary oppositely sloped surfaces for engaging said formation.

72. **(Original)** A frame member as claimed in claim 71, wherein the sloped surfaces of said third member slope downwards towards a centre line through said third spacer between opposed sides thereof, and complementary surfaces of the base of said channel slope downwards towards the centre of said channel.

Claim 73 **(Cancelled)**

74. **(Previously Presented)** A spacer for use in mounting a panel within a channel of a frame member, comprising a base portion for spacing said panel from the base of said channel;

two side portions extending from said base portion for spacing said panel from respective side walls of said channel; and

protrusions extending from said side portions for engaging opposite faces of said panel and for resiliently retaining said panel in said frame member.

75. **(Previously Presented)** A spacer as claimed in claim 74, wherein said protrusions extend from upper ends of said side portions.

76. **(Previously Presented)** A spacer as claimed in claim 74, wherein the side portions include respective recesses below said protrusions to allow said protrusions to flex toward said base portion.

77. **(Previously Presented)** A spacer as claimed in claim 74, wherein said protrusions have respective upper surfaces which are directed towards said base portion when said protrusions are in an unstressed condition.

78. **(Previously Presented)** A spacer as claimed in claim 74, wherein said protrusions are formed by respective extensions of said side portions which are folded such that said protrusions extend from said side portions.

Claim 79 **(Cancelled)**

80. **(Previously Presented)** A spacer as claimed in claim 74, wherein said side portions are integrally formed with said base portion and junctions between said base portion and said side portions have a reduced thickness to hingedly couple said portions together.

81. **(Previously Presented)** A spacer as claimed in claim 80, wherein a region adjacent said junctions of said base portion and said side portions are relieved to accommodate folding of said side portions towards said base portion.

Claims 82 and 83 **(Cancelled)**

84. **(Previously Presented)** A spacer as claimed in claim 74, wherein the surface of the spacer which engages said channel includes means for positioning said spacer within said channel at a predetermined transverse position.

85. **(Previously Presented)** A spacer as claimed in claim 84, wherein said positioning means comprises oppositely sloped lower surfaces of said base portion and wherein said oppositely sloped surfaces slope downwards towards an axial centre line through said base portion.

Claim 86 **(Cancelled)**

87. **(Previously Presented)** A spacer as claimed in claim 74, wherein said base portion includes means for permitting fluid to flow therethrough between adjacent portions of the channel separated by said spacer when inserted in said channel.

88. **(Previously Presented)** A spacer as claimed in claim 74, wherein the outer surfaces include a low friction layer or coating.

Claim 89 **(Cancelled)**

90. **(Previously Presented)** A spacer as claimed in claim 74, wherein the surfaces of said protrusions for engaging said panel are relatively high friction surfaces.

Claim 91 **(Cancelled)**

92. **(Previously Presented)** A framed panel unit as claimed in claim 1, at least one of said side walls of each said frame member having an elongate recess formed therein extending along the channel and positioned below the top of a respective sidewall.

93. **(Previously Presented)** A framed panel unit as claimed in claim 92, wherein the upper edge of said recess is substantially perpendicular or angled downwardly from the recess towards said channel with respect to a line directed from the base to the top of said channel.

94. **(Previously Presented)** A framed panel unit as claimed in claim 92, wherein said channel includes a base having oppositely sloped upper surfaces transverse to said channel.

95. **(Previously Presented)** A framed panel unit as claimed in claim 1, wherein said spacer means centers said panel within said channel.